	Work Order ID 58660 hursday, May 13, 2010 10:26:51 AM											Page
Item ID: Revision ID:	D3913-041			Accept					Setup	Start		
	5/13/2010	Start Qty: 1.00 Req'd Qty: 1.00	188131 HO 1881 188131 HO 1881		Cust Item l Customer:	D:				Stop		HE HE HE HE
		nn: MF	Date: <u>(0</u> -5 - /3 Date:	Tooling: SPC (Y/N):		ate:		1		Start Stop	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr	,									
D3913	A											
100 Large Fab Large Fab		Memo 1- assemb ***inspec 2- tack we 3- weld his	S. rod Batch: MII3328 le ribs, weld as per dwg D391 to before welding mesh*** eld mesh on basket as per dwg I nge (3) and Mounting brackets d to locate hinge and bracket**	0.00 3 using DT9610A D3913 and trim mesh as per dwg D3913	to fit		,	S	5 10	Jos	-/25	(1)

110

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

10.05.25

W/O:			GES	S							
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Cat	egory:	_ NCR						
	R	esolution:	Disposition: Q			N/C Clo	sed:		Date:		
NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC			tion B	0: 0	Verific	ation	Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		on C	Chief Eng	QC Inspector	
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Work	Order	ID	58660
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Thursday, May 13, 2010 10:26:51 AM



Page 2

Item ID:

D3913-041

Accept



Setup Start



Revision ID: Item Name:

Long Basket Base Assemby, 350

Cust Item ID:

Start Date:

5/13/2010

Start Qty: 1.00 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Date:

Start

Stop



Required Date: 5/19/2010

____ Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**

120



Quality Control

Operation **Description**

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** Draw Number Draw Plan Rev. Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

Memo

0.00

0.00

Run

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo //// 14203 Plug holes and mask only interior of hinge (3) prior to powder

=) H) 10105/26 X+

1ST COAT:

coat

START TIME: 0:300 m

START TIME: 9:30 AM

FINISH TIME: 10160 AL

W/O:			ES						
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			<u> </u>						
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	\ \ :	Date:	
		esolution:							
NCR:				R NON-CONFORMA					
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
	-	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Section C		Chief Eng	QC Inspector	
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Work Order ID 58660

Thursday, May 13, 2010 10:26:51 AM



Page 3

Item ID:

D3913-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Long Basket Base Assemby, 350

Start Date:

5/13/2010

Start Qty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Draw

Rev.

Plan

Code

Start

Reject

Qty

Stop

Reject

Run

Accept

Qty



Insp.

Required Date: 5/19/2010

Sequence ID/ Work Center ID

140

QC

Quality Control

Operation Description

QC: _____

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Number Stamp

150



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

Memo

Pick Kit

0.00

160



Quality Control

QC5- Inspect part completeness to step on W/O

W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date (Qty Chief	roval Eng / I Mgr Approv QC Inspec						
			·											
Part No	Part No: PAR #: Resolution:			egory:	No DQA:	A: Date:								
	Resolution:		Dispositi	on:	QA: N/C Clo	osed:	Da	ıte:						
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCR)								
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	etion B	Verificat								
		Section A	Chief Eng	Chief Eng	Date	Section	C Chief	f Eng QC Inspec	tor					
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Work Order ID 58660

Thursday, May 13, 2010 10:26:51 AM



Page 4

Item ID:

D3913-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Long Basket Base Assemby, 350

Start Date:

Required Date: 5/19/2010

5/13/2010

Start Qty: 1.00

Reg'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

170

Packaging

Operation Description

Identify as per dwg & Stock Location: 6. A

W/ B58777

0.00

Draw Number

Draw Plan Rev. Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

Packaging

Memo

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/26 td) CZ1015/26

W/O:			ES				·						
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes No DQA: Date:								
		esolution:											
NCR:				R NON-CONFORMA									
DATE	STEP	Description of NC		ion B	Verific	cation	Approval	Approval					
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector				
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Picklist Print												Page 1
Thursday, May 13, 2	2010 10:26:48 AM			APR-14-14			<u></u>					1
Work Order ID: 58	3660					- ***						6
Parent Item: D3	3913-041											
Parent Item Name:	Long Basket Base A	ssemby, 350						S	tart Date: 5/13	3/2010	Required Date: 5	/19/2010
Comments:	IPP Rev:A new iss chg qty's DD 10.04			d by:EC	IPP Re	ev:B		\$	Start Qty: 1.00)	Required Qty: 1	.00
Component Item ID/ Item Name		-	Bin	Primary Location	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
AN3-10A	Item ID	Purch Purchased	No	Location	Location	Seq ID 150	Measure Each	Hand 88.0000	6	Issued	Issued	
Bolt												
				Locatio	<u>on</u>	Lo	c Oty	Loc Code				/
		0 0=		ST351			88		_		do (dos	126
AN960JD8 4 ((4)	9 DN 8327	- (feryst o	01 F		114330	150	88 East	0.0000	_	ے		
		Purchased	INO			150	Each	0.0000	2 		So (dos	1 (1)
Washer	iilo 1881 2811 1881					4	11474	0		ي ج	Sis (8/05	124 (I)
D2581		Manufactured	No			100	Each	36.0000	2			
Mounting Bracket												
				Locatio	<u>n</u>	<u>Lo</u>	c Otv	Loc Code				
				WA			36		_			(4
					46086 51745		2 2		_			- 1261)
					57185		9		_		Sp (0)	05 1000
D2021					58301		23			(a)		
D2931	I	Manufactured	No			150	Each	864.0000				
Pumper												
Bumper				<u>Locatio</u>	n	Lo	c Qty	Loc Code				. (
				ST504	-	<u>20</u>	864	201 0040			o^{-1}	126()
					46064		864			2	Sn islos	-1
D3913-1	I II I (III II II I	Manufactured	No			100	Each	1.0000	1 1 (14) (14) (14)			0.1
Dib										B 58	3777 (1)	M10/05/
Rib				<u>Locatio</u>	n	Lo	c Oty	Loc Code			_	
				WA	-		1					
		•			58124		1					

	-									
W/O:			ORK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			· · · · · · · · · · · · · · · · · · ·				_			
Port No		DAD #					_			
rail NO					NCR: Yes No DQA: Date:					
	К	esolution:						Date:		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval Chief Eng	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C		QC Inspector	
	ļ									

Status

Thursday, May 13, 2010 10:26:49 AM

Work Order ID: 58660

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 5/13/2010

Start Qty: 1.00

Required Date: 5/19/2010

Required Qty: 1.00

Date

Component Item ID/ Item Name D3913-15

Item ID

Replacement Mfg/ Purch Manufactured Bin Primary Item Location No

Last Location

Route Seq ID 100

Unit of Qty on Measure Each

Hand 11.0000 Qty per Kit Qty Issued

Issued

Wide Handle Plate

D3913-3

Manufactured

No

58125

Loc Qty 11 11 100 Each

Loc Qty

Loc Oty

2 2 2.0000

Loc Code

B58578 DM 10/05/18

Rib

Manufactured No 58126

Location

WA

Location

WA

100

Each

2.0000

Loc Code

Loc Code

B58579 D M 10/05/18

Rib

D3913-7

D3913-9 Hinge Rib Manufactured No Location WA

58127

58128

100

2 Each

2

2

2.0000

Location WA

Loc Qty

Loc Code

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	, (Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	Part No: PAR #:												
	R	esolution:					ed:		Date:				
NCR:		1	WORK ORI	DER NON-CONFORM	ANCE (N	CR)							
DATE	STEP	Description of NC	1		ction B		Verificat	ion	Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section	С	Chief Eng	QC Inspector			
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Thursday, May 13, 2010 10:26:49 AM

Work Order ID: 58660

D3913-041

Parent Item Name:

Parent Item:

Long Basket Base Assemby, 350

IPP Rev:A new issue DD 10.03.19 verified by:EC Comments: chg qty's DD 10.04.12 verified by:EC



58357

IPP Rev:B

Start Date: 5/13/2010

Start Qty: 1.00

Required Date: 5/19/2010

Required Qty: 1.00

Component	Item	ID/
Item Name		
D3916-041		

Replacement Mfg/ Item ID

Purch Manufactured Bin Primary Item Location No

Last Location Route Seq ID 100

Unit of Measure Each

Qty on Hand 2.0000

Loc Code

Loc Code

9.0000

4.0000

Oty per Kit Otv

Date Issued Issued

Status

Page 3

Location

Location

WA

WA

2

Rib Assembly

D3916-5

ight Rib⊿اط

Manufactured No

Loc Qty 2 100

Each 14.0000

Location Loc Qty WA 14 57023 2 57982 9 58360 3 100 Each

D4016-1

Hinge Half, Base

D4017-7

Rib

Manufactured No

Manufactured

Loc Qty Loc Code 58132 9

Each

100

Location Loc Qty Loc Code WA 57989 2 58133 2

W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	<u>.</u>							
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NCR:			WORK ORDE	R NON-CONFORM	IANCE (NCF	₹)							
DATE	STEP	Description of NC		ction B	Verific	ation	Approval	Approval					
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector				
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Thursday, May 13, 2010 10:26:49 AM

Work Order ID: 58660

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 5/13/2010

Required Date: 5/19/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name D4017-9

Replacement Item ID

Mfg/ Purch Manufactured

Bin Primary Item Location No

Last Location Route Seq ID 100

Unit of Measure Each

Qty on Hand 8.0000

Oty per Kit 2

Otv Issued Date Issued

Status

Rib

WA

No

Manufactured No

Loc Qty 6

Each 100

0.0000 B58416

Loc Code

Mesh (350 Basket Long, Base) D4020-11

D4020-1

End Mesh, Basket

Manufactured No

Manufactured

100

Each

14.0000

2

Location WA

Location

56990 58136

58134 58415

> Loc Oty 14 1 13 100 Each

Loc Code

10.0000

1358525 B

Handle Plate

D4021-1

Location Loc Qty ST109 5 57086 5 WA 5 58139 5 Loc Code

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Thursday, May 13, 2010 10:26:49 AM

Work Order ID: 58660

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

Parent Item:

IPP Rev: A new issue DD 10.03.19 verified by:FC



IDD Day: D

Start Date: 5/13/2010

Required Date: 5/19/2010 Required Oty: 1.00

Start Oty: 1.00

	P Rev:A new iss g qty's DD 10.04			d by:EC	IPP Re	v:B			Start Qty: 1.00		Required Qty: 1.0	00	
Component Item ID/ Item Name D4021-5	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID 150	Unit of Measure Each	Qty on Hand 13.0000	Qty per Kit	Qty Issued	Date Issued	Status	
Blanking Plate				Location	<u>1</u>	Loc		Loc Code		3	Sus colo	sla L	75
				ST109	58140		13 13		<u></u>	2	OB CCC	9 2 6	0
D4034-041 Aft Upper Rib Assembly		Manufactured	No			100	Each	5.0000		JJ 10	105/18		_
				Location	1	Loc	<u>Oty</u>	Loc Code					
D4034-043 Fwd Upper Rib Assembly	 	Manufactured	No	WA	58141	100	5 5 Each	5.0000	1	D Sy 1	10/05/18)	_
				Location	<u>1</u>	Loc	Oty	Loc Code					
				WA	58142		5 5			<u></u>			
MS20600-AD4W3		Purchased	No		<u>-</u>	150	Each	1,825.000	2				

Cherry Rivets

<u>Location</u>	Loc Oty	Loc Code
ST321	1825	
106375	3	
107939	822	
111636	1000	

== Sis ralos/260

W/O:			WC	RK ORDER CHANG	ES	·			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Picklist Print

Page 6

Thursday, May 13, 2010 10:26:49 AM

Work Order ID: 58660

D3913-041



Parent Item Name:

Long Basket Base Assemby, 350

Comments:

Parent Item:

IPP Rev:A new issue DD 10.03.19 verified by:EC

chg qty's DD 10.04.12 verified by:EC

Start Date: 5/13/2010

Required Date: 5/19/2010

Start Oty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			150	Each	1,561.000	6			
Nut												
				Location		Loc (Qt <u>y</u>	Loc Code				
				CT200			1561					,

IPP Rev:B

NAS1149F0332P Purchased

No

1561 ST300 113537 20 113644 541 114523 1000 150 Each

887.0000

= 80 (olos/20 0)

12

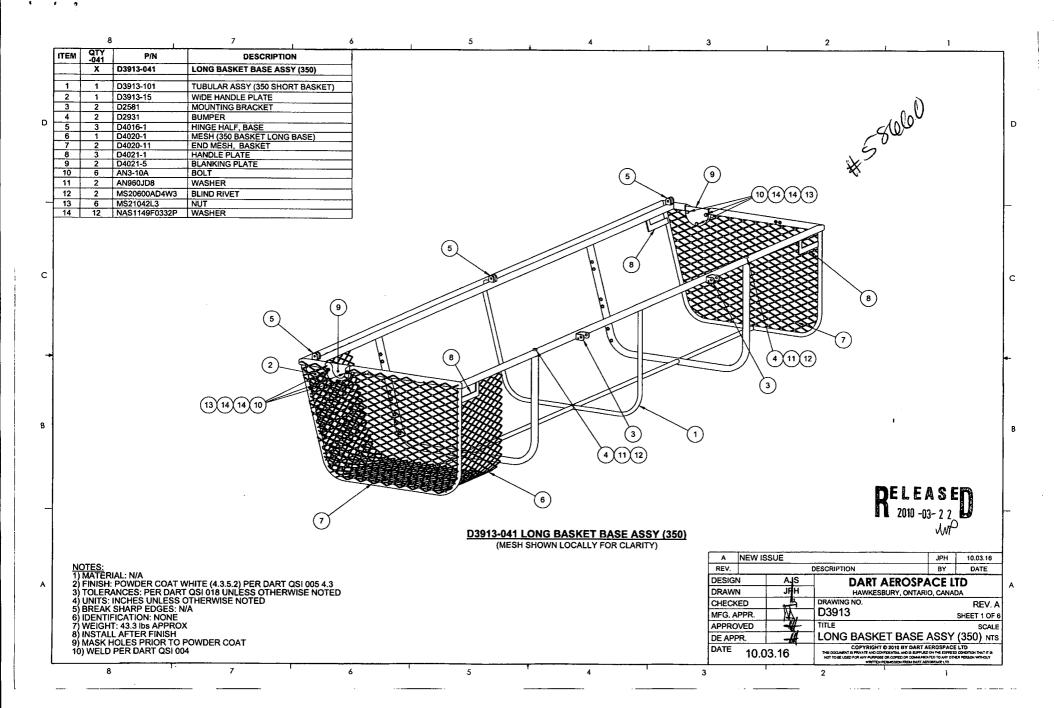
WASHER

Loc Code Location Loc Qty 887 ST275 18057 887

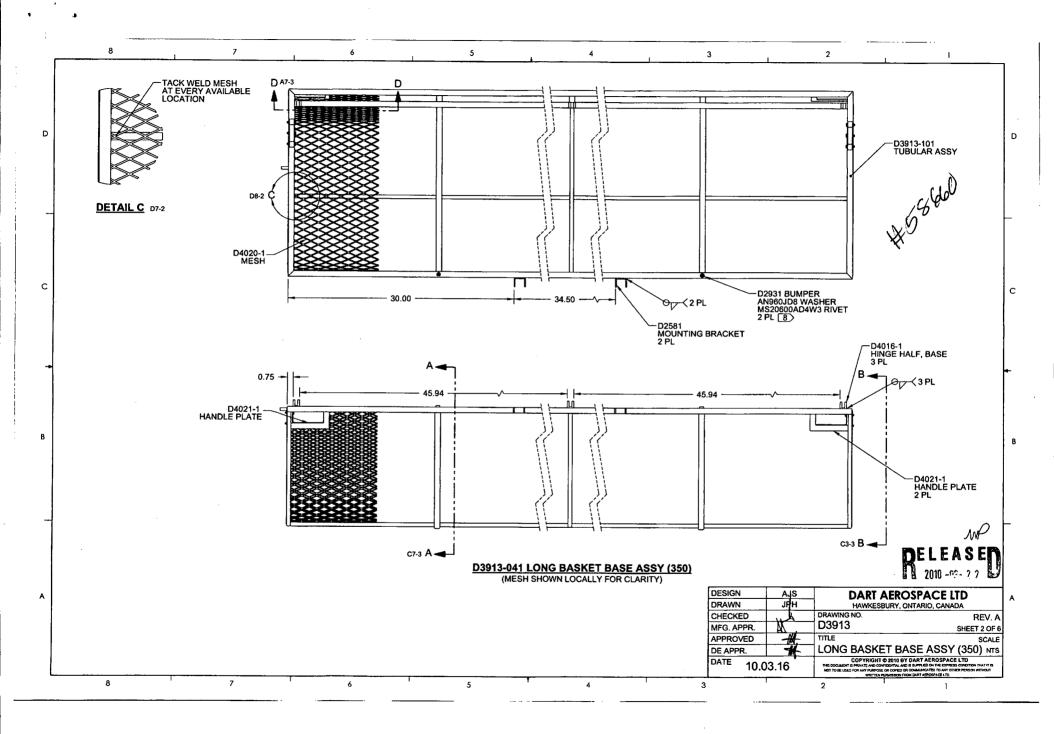
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W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP		OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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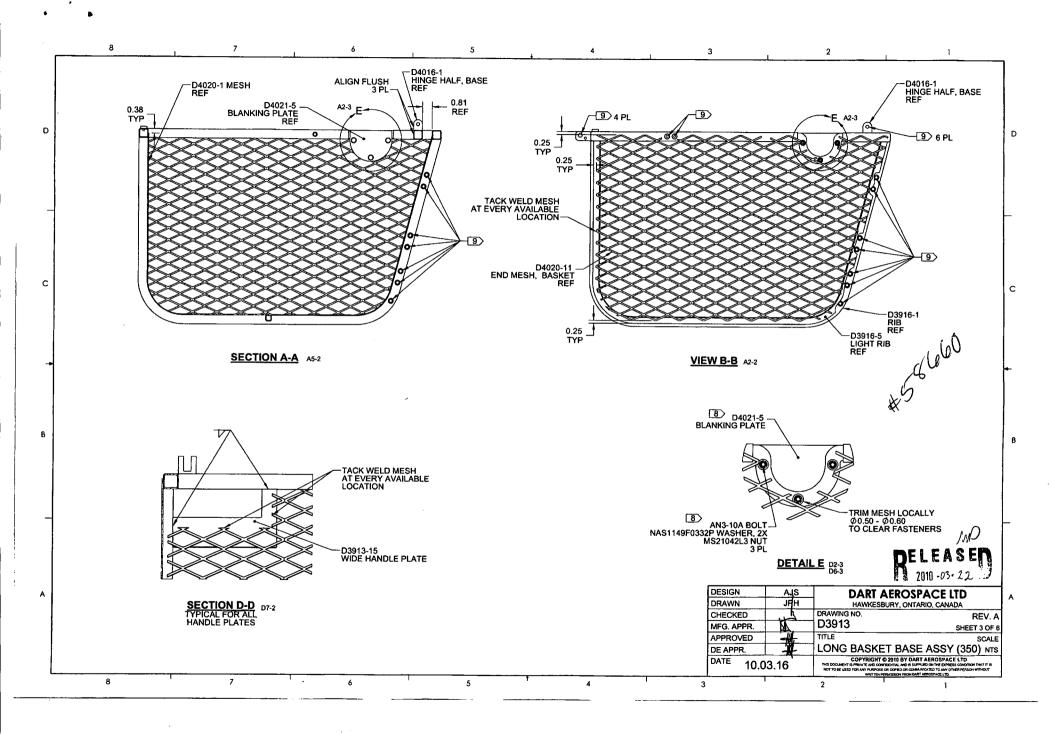
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NCR:			WORK ORDI	R NON-CONFORMA	NCE ((NCR)				
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		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Part No	·	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQA: _	Date: _					
		olution:											
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DATE	STEP	Description of NC		Corrective Action	Section B		Verification	n Approval	Approval				
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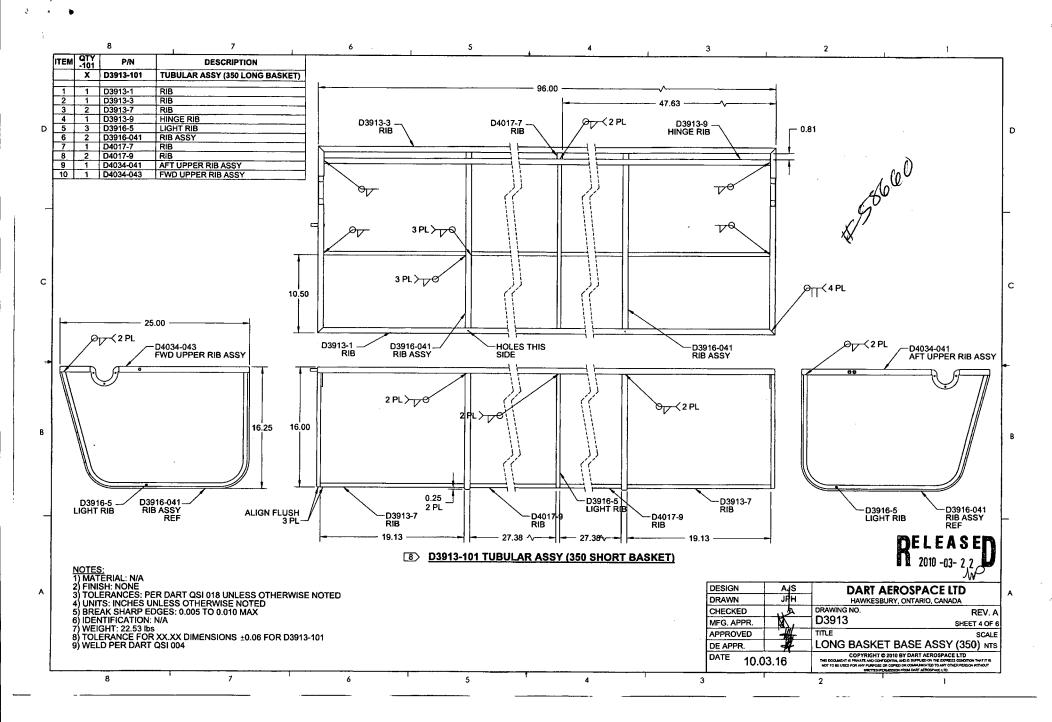


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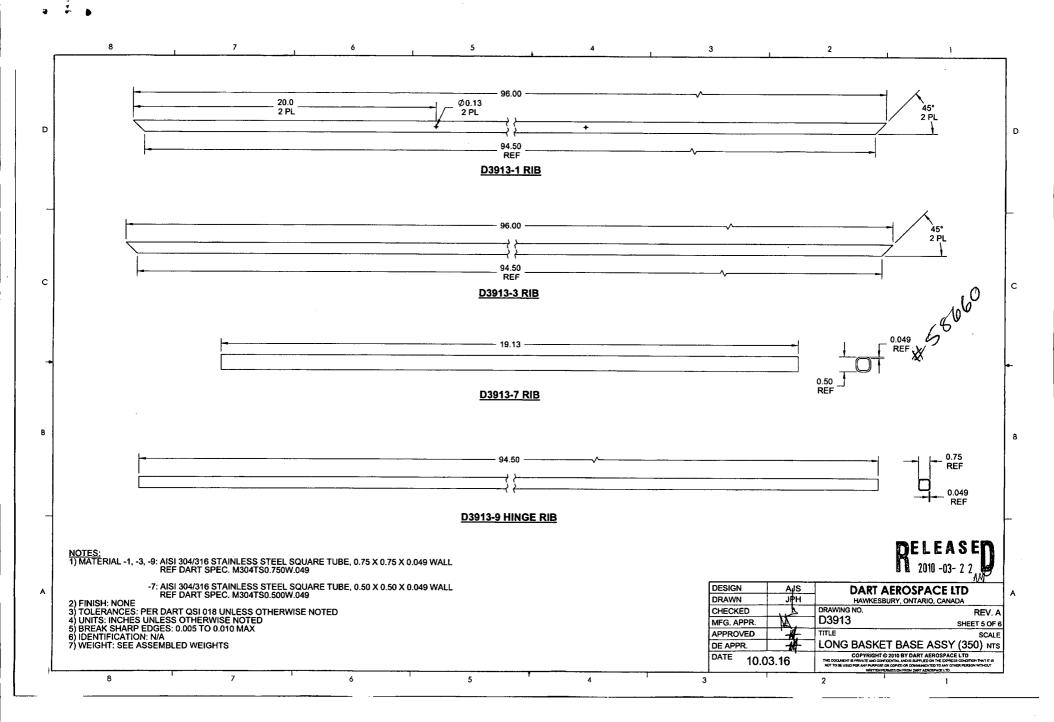
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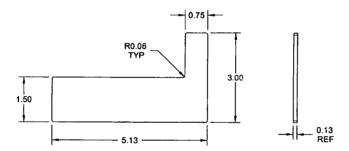
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:		PAR #:	Fault Cat	tegory:	·	NCR: Yes	Date:					
	R	esolution: Disposition:				QA: N/C CI	osed:	Date:				
NCR:			WORK ORI	DER NON-CO	NFORMAN	CE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Se				Verification	cation Approval Approva				
			Initial Chief Eng	Action D	escription of Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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D3913-15 WIDE HANDLE PLATE

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304511GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA					
CHECKED		DRAWING NO. REV. /					
MFG, APPR.	77	D3913 SHEET 6 OF					
APPROVED	`##-	TITLE SCALI					
DE APPR.	4 -	LONG BASKET BASE ASSY (350) NTS					
DATE 10.0	3.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT OF PRIVATE AND CONTRIBUTION IN SUPPLIED ON THE EXPRESS CONDITION THAT IT IS					

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DATE	STEP	·	, ,PROC	ROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
<i>y</i>											
			Special Control				:	· ,*			
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		PAR #:	·	_ Fault Cate	egory:	NC	R: Yes	No DQ .	A:	Date: _	
		esolution:	1	Disposition: Q				A: N/C Closed:			
NCR:			W	ORK ORE	DER NON-CON	FORMANC	E (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B			Verification		Approval Approva		
		Section A		Initial Chief Eng	Action Desc Chief En	eription g	Sign Date	& Secti		Chief Eng	Approval QC Inspecto
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